

Date: Wednesday, 6/28/2006 10:14:19 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WEARPLATE
Job Number :	27710		
Estimate Number :	12461		
P.O. Number :	N/A	Part Number :	D35081
This Issue :	6/28/2006	Drawing Number :	D3508 PREL
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	N/A	Drawing Revision :	PREL
Previous Run :	N/A	Material :	N/A
Written By :	Due Date :		7/5/2006
Checked & Approved By :	Qty:		2
Comment :	Um:		Each

Type : SMALL / MED FAB

Comment : Est Rev A New Issue 06-06-20 JLM

Short

See COMMENT BELOW

06.06.28

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.2489 sf(s)/Unit Total : 0.4977 sf(s)
 1010/1025/A21/6aA SHEET
 (M1010S20GA)
 Batch: *M100473*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3508
 Dwg Rev: *Prel*
 Prog Rev: *Prel*

2-Deburr if necessary

*SAD 06:06:28**(2)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE*SAD 06:06:28**(2)*

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK*06/07/03*

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Deburr and form on brake using DT8178 and DT8261 as per Dwg D3508

*SB**06/07/04**(2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 06/07/07

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Drawing Name: WEARPLATE

Job Number: 27710

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Handwritten notes:
Date
Return to PH
06/07/07
26-07-07
J.M.

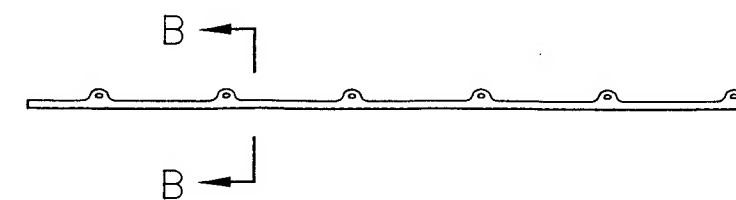
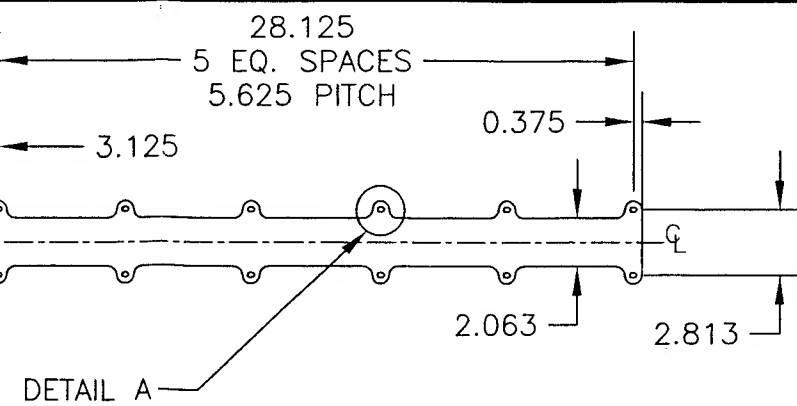
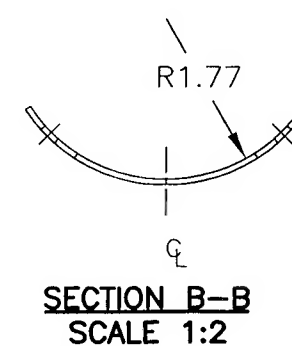
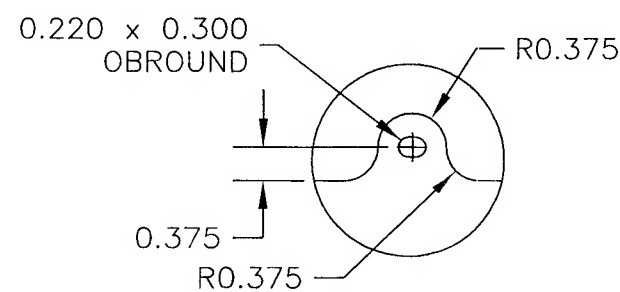
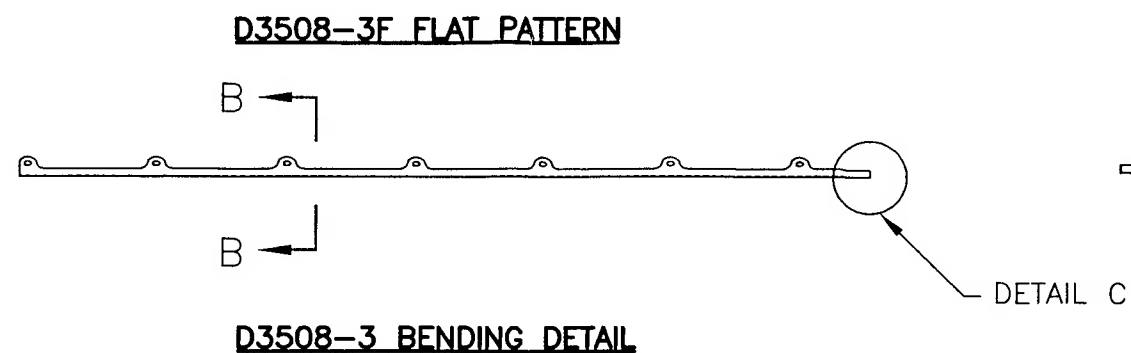
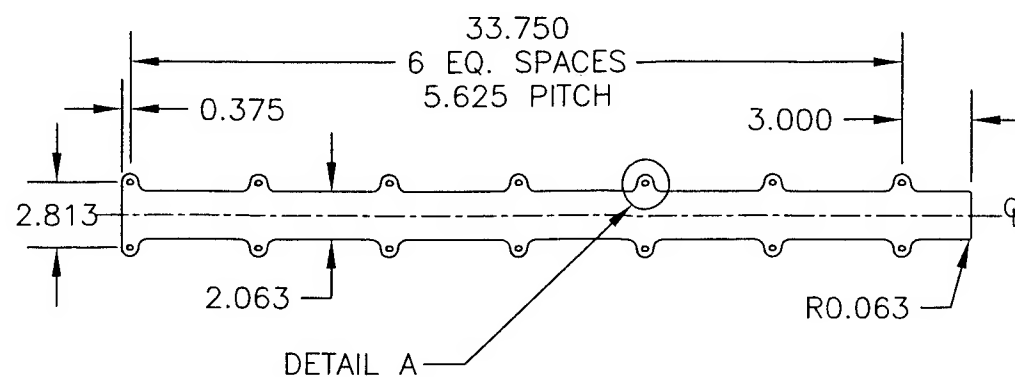
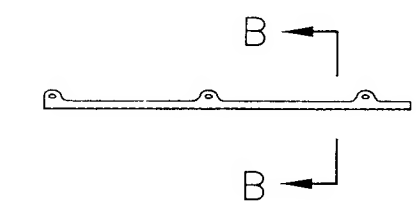
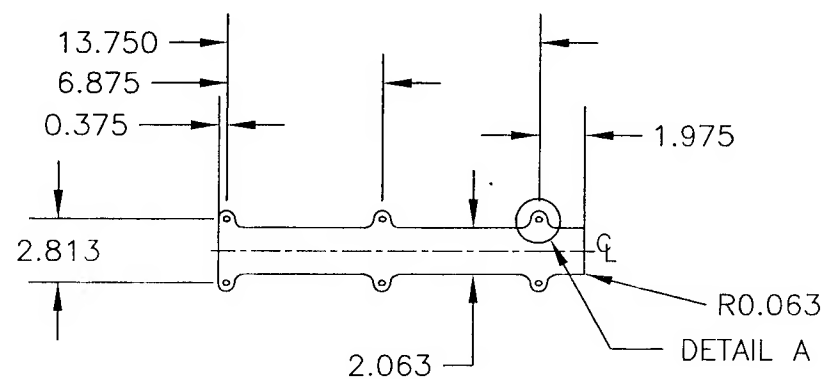
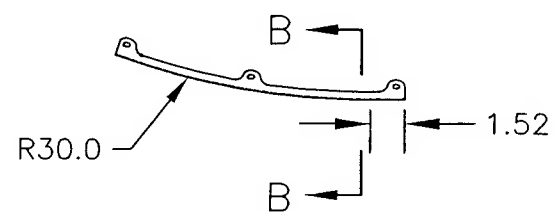
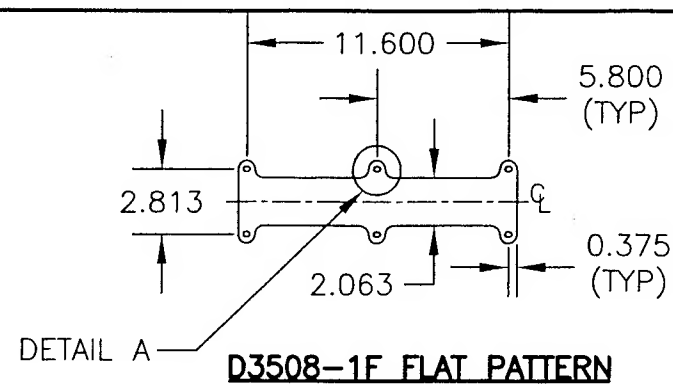
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

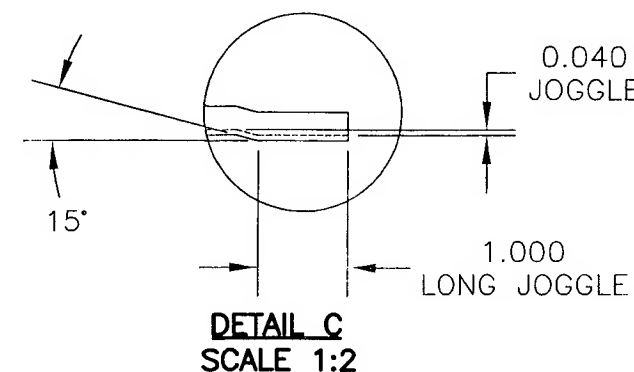
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **27710**




D3508-1/-3/-5/-7 WEARPLATE NOTES

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 20 GAUGE (0.040 THICK) (REF DART MATERIAL SPEC M1010-S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE

PRELIMINARY ISSUE

COPYRIGHT © 2006 BY DART AEROSPACE USA, INC.		A	06.04.21	NEW ISSUE
DESIGN	PH	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED		APPROVED		DRAWING NO. D3508
DATE	06.04.21	TITLE	WEARPLATE	REV. A SHEET 1 OF 1 SCALE 1:1

00100473



COMERCIAL DEL OROSCO S.A.
MATANZAS - VENEZUELA

CERTIFICADO DE CALIDAD / MILL TEST CERTIFICATE

PAGINA: 01-A

Nº DE CERTIFICADO: 04210437 ID: 28925

CS TECHINTRADE CORP. 2200 WEST LOOP SOUTH, SUITE 750 HOUSTON, TEXAS 77027.	DE MONTREAL, CANADA DE SI TP I NT OO	OCOMPRAS - Purchase Ord. Nº * OVENTA - RN - Bidor Ord. Nº SA98616 -07 DESPACHO - Shipper Nº FACTURA - Invoice Nº VEHICULO - Vehicle IDA
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PRODUCTO PRIME NEWLY PRODUCED COLD SAMUEL. SON & CO J15000 /	ROLLED STEEL COILS TECHINTRADE S.O. 100000217	ASTM A 1008 CS TIPO-B
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COLOUR MARK	SIZE 0.0550 MIN X 48.000	TIPO DE ANALISIS HEAT PHYSICAL TEST
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PHYSICAL TEST					CHEMICAL COMPOSITION - %															
Nº COLADA Heat Nº	Nº DE MUESTRA Sample Identification	TRACCIÓN			DRZ	DOB	C	MN	P	S	SI	CU	AL	MO	NB	V	NI	CR	B	
		ESF Y.P	ESF UTS	% AL	-1	-2	-2	-3	-3	-3	-3	-3	-3	-3	-3	-3	-3	-3	-3	-4
		MPA	MPA	002P	X10	180	X10	X10	X10	X10	X10	X10	X10	X10	X10	X10	X10	X10	X10	X10
		HRB	GRAD																	
	MCN	1.00	2.00	1.00		2							20							
	MAX.				600	15	60	30	35	100	200	80	60	8	8	200	150	10		
243097		214.00	312.00	40.00	490	OK	005	028	010	004	023	010	029	004	001	001	011	013	000	
544031		215.00	336.00	38.00	500	OK	006	028	009	004	064	002	029	002	001	001	003	006	001	
644146		187.00	274.00	38.00	580	OK	007	033	009	001	032	007	025	002	001	001	005	009	000	

C43748

OBSERVACIONES / NOTE

COMERCIAL DEL OROSCO S.A.
 Gerencia de Gestión de Calidad
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